

Date: Friday, 10/5/2007 11:02:15 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	PANEL
Job Number	35047			
Estimate Number	10873			
P.O. Number	N/A		Part Number	D32455
This Issue	10/5/2007	S.O. No.	Drawing Number	D3245 UNDER REVIEW
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A		Drawing Revision	A
Previous Run	34607		Material	N/A
Written By			Due Date	10/19/2007
Checked & Approved By	HJ 07-10-05		Qty:	8
Comment	Est. A 04.07.07 New issue KJ/JLM		Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304S22GA	304/316 .032 Sheet  8.4420
	Comment: Qty.: 0.8442 sf(s)/Unit Total : 6.7536 sf(s) 304/316 .032 Sheet Batch: M105262 B07-10-18	
2.0	WATER JET	FLOW WATER JET  
	Comment: FLOW WATER JET 1-Cut as per Dwg D3245 Dwg Rev: A B07-10-18 Prog Rev: A	(10)
	2-Deburr if necessary B07-10-18	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  B07-10-18
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK  
	Comment: SECOND CHECK	Locators Er 07/10/19 410
5.0	BRAKE NC	NC BRAKE  
	Comment: NC BRAKE Deburr if necessary Form D3245-5 as per Dwg D3245 Identify as D3245-5	SB 07/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/1/20 \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 10/5/2007 11:02:15 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 35047

Part Number: D32455

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



07/11/20 X10

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 79

JS 07/11/20 10X W

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/20 P

Job Completion



07/11/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

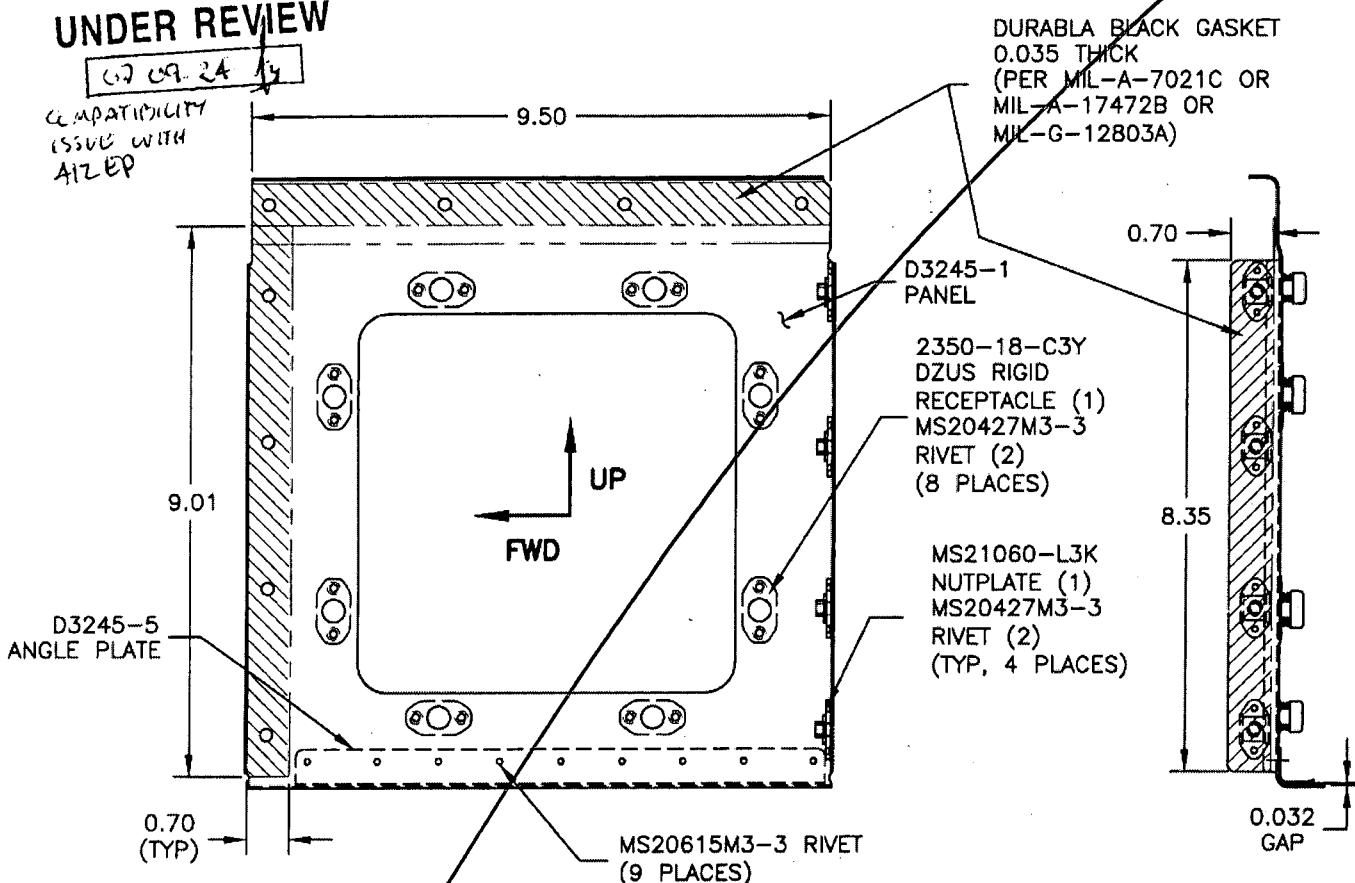
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED <i>AA</i>	APPROVED <i>AA</i>	DRAWING NO. D3245	REV. A SHEET 1 OF 6
DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3
A	04.01.27	NEW ISSUE	

**RELEASED**  
(04.04.21 *AA*)**UNDER REVIEW**07 09 24 *IP***D3245-041 ACCESS PANEL ASSEMBLY****D3245-041 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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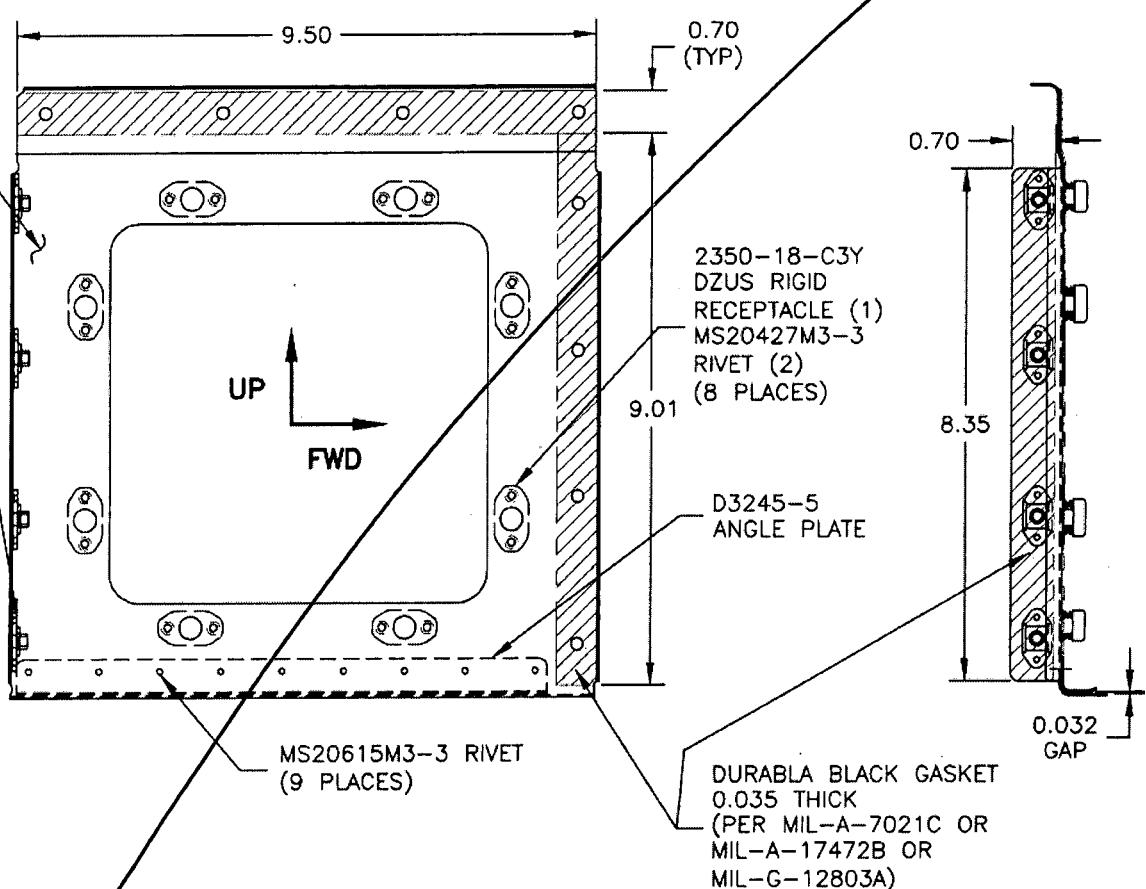
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3	

**RELEASED**  
04.01.27**UNDER REVIEW**

04.09.24

COMPATIBILITY  
ISSUE WITH  
A12 EPD3245-2  
PANELMS21060-L3K  
NUTPLATE (1)  
MS20427M3-3  
RIVET (2)  
(TYP, 4 PLACES)**D3245-042 ACCESS PANEL ASSEMBLY****D3245-042 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) INSTALL GASKET USING 3M SCOTCH-GRIP P/N 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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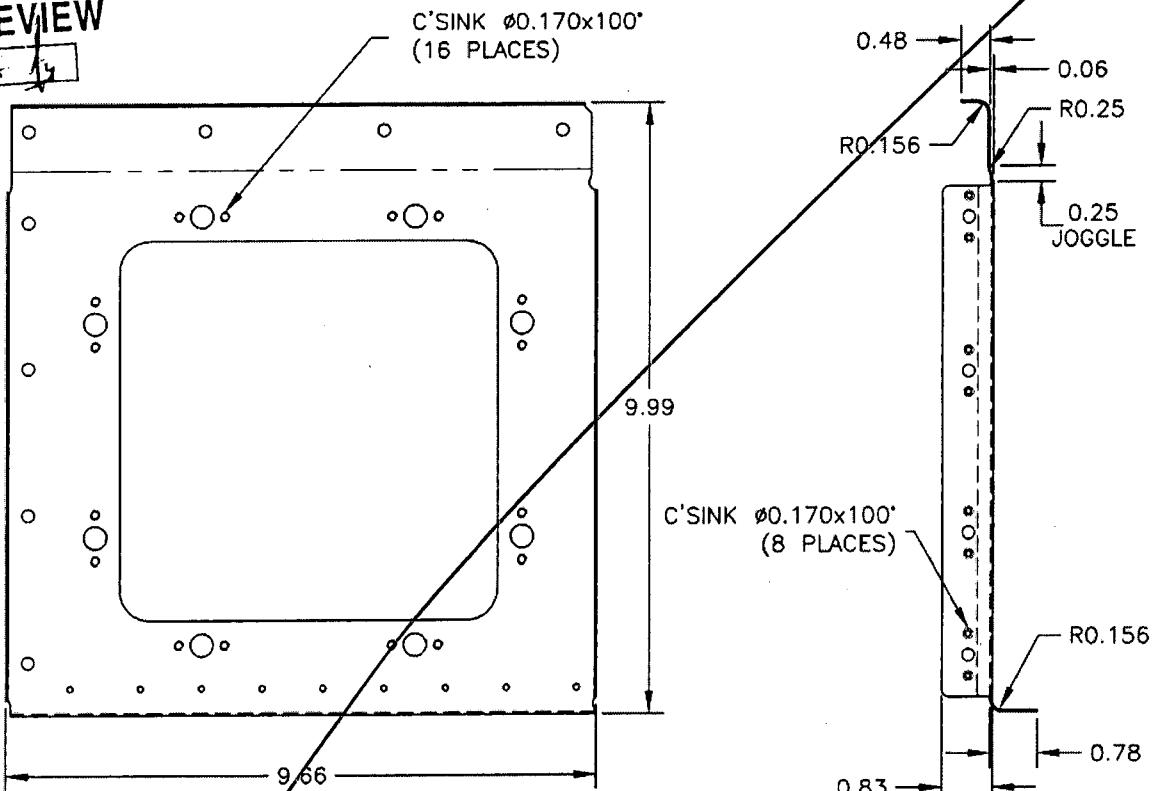
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY	SCALE 1:3	

**RELEASED**

04.04.21

**UNDER REVIEW**

07.09.24

COMPATIBILITY  
ISSUE WITH  
A12 EP**D3245-1 PANEL BEND DETAIL SHOWN  
BEND D3245-2 PANEL OPPOSITE**

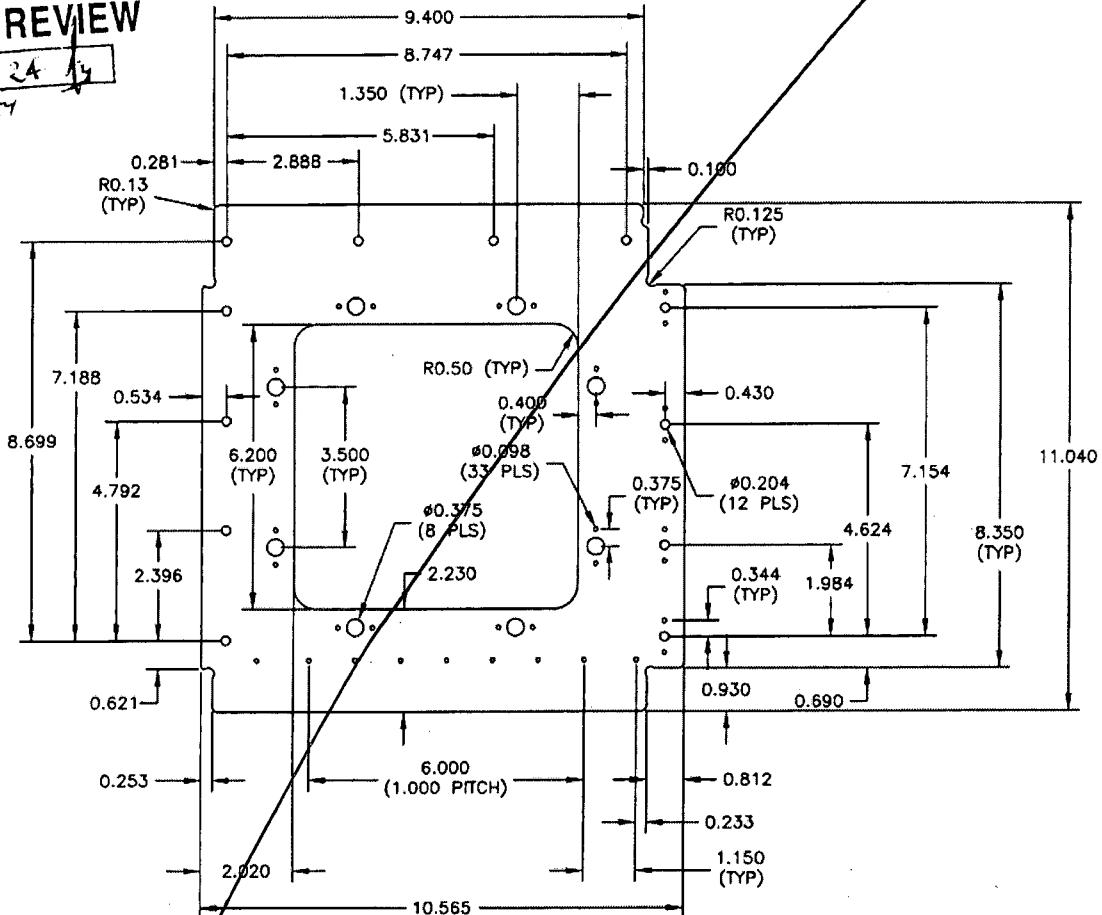
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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY	REV. A SHEET 4 OF 6 SCALE 1:4

RELEASED  
04.04.21 *H*UNDER REVIEW  
*07.09.24*COMPATIBILITY  
ISSUE WITH  
A12 EP**D3245-1/-2 PANEL FLAT PATTERN**NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) ALL DIMESIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

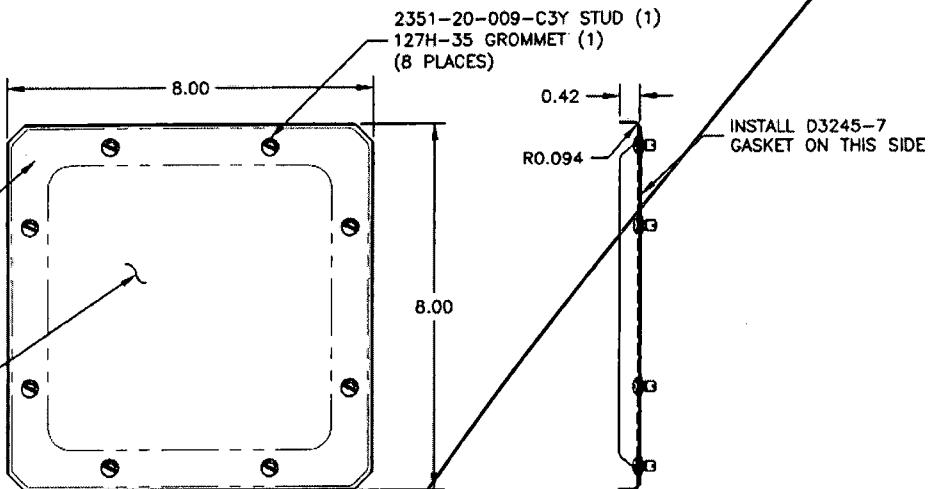
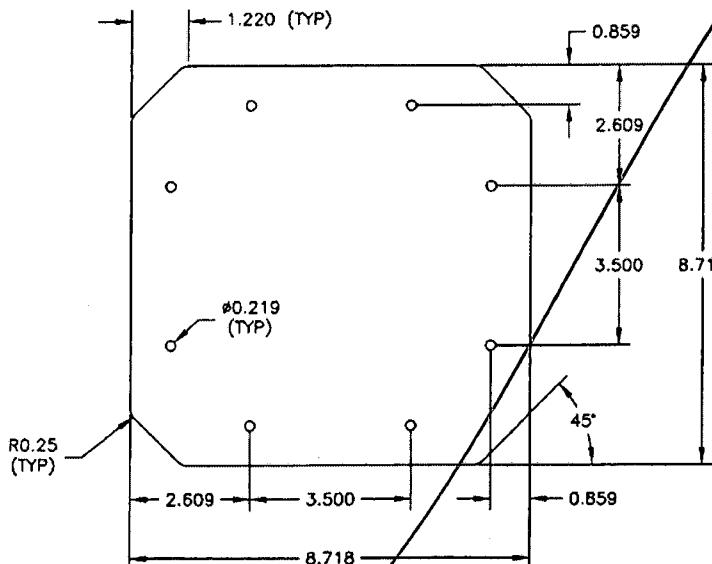
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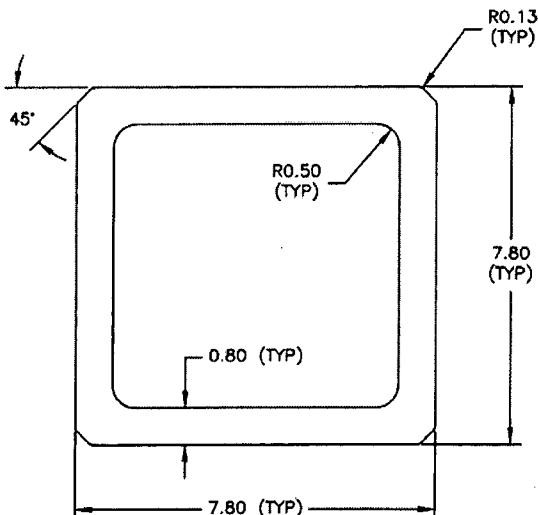
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DATE 04.01.27		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

**RELEASED**04.04.21 *CH***UNDER REVIEW**07.09.24 *IP*COMPATIBILITY  
(ISSUE WITH D3245-5 DOOR  
A12 E&P)**D3245-043 DOOR ASSEMBLY****D3245-3 DOOR FLAT PATTERN**MATERIAL: AISI 304/316 SS 0.032 THICK  
ANNEALED (REF. M304S22GA)**D3245-043 NOTES:**

- 1) FINISH: NONE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE  
IN ACCORDANCE WITH THE MANUFACTURER'S INSTRUCTIONS
- 6) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 7) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

**D3245-7 GASKET**MATERIAL: DURABLA BLACK GASKET 0.035 THICK  
(PER. MIL-A-7021C OR MIL-A-17472B  
OR MIL-G-12803A)

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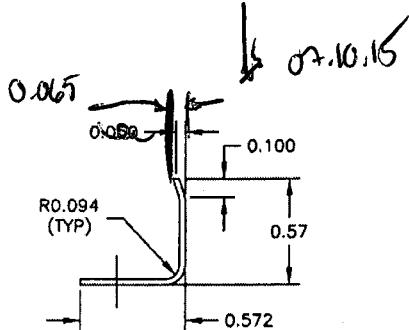


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DATE 04.01.27	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4	

RELEASED  
04-04-05

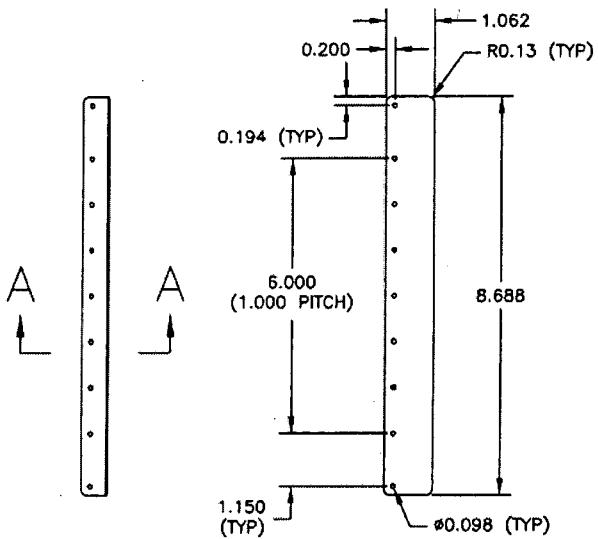
UNDER REVIEW

## COMPATIBILITY ISSUE WITH AIZEP



**D3245-5 BEND DETAIL**

**VIEW A-A  
SCALE 1:1**



**D3245-5 FLAT PATTERN**

OK per Rev. A  
07.10.15

D3245-5 NOTES:



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DART AEROSPACE LTD.	Work Order:	35047
Description: PANEL	Part Number:	D3245-5
Inspection Dwg: D3245 Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	HB	Audited by:	en	Prototype Approval:	<input checked="" type="checkbox"/>
Date:	07-10-18	Date:	07/10/19	Date:	<input checked="" type="checkbox"/>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	